

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008697**Date Inspected:** 10-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi jiang/ Zhang Yaxu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

During random visual inspection of CB-012, Caltrans Quality Assurance (QA) Inspector discovered a total of (2) Two, full length (45mm and 30mm) linear indications in Tack Welds. The member is identified as OBG Cross Beam. The weld designations reviewed are as FB204-033-065 and FB204-035-066. Caltrans Quality Assurance (QA) Inspector also evaluates those linear indications by Magnetic Particle testing. This QA inspector generated a TL 015 incident report on this date.

During random visual inspection of CB-012, Caltrans Quality Assurance (QA) Inspector discovered a excessive root opening on weld joint FB204-033-063. According to approved WPS-B-T-2231-B-U2-F, root opening is 0~3mm (+2, -0mm). The recorded root opening is 9~10 mm. This QA inspector generated a TL 015 incident report on this date.

Bay #2

This QA inspector observed that all the required NDT work is completed on Longitudinal Diaphragms and item ready for green tag. This QA Inspector issued green tags for Longitudinal Diaphragms on this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB011-028) Green Tag- 009953.

-(FB011-030) Green Tag- 009954.

-(FB011-033) Green Tag- 009956.

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Bay #3

This QA inspector observed that all the required NDT work is completed on Longitudinal Diaphragms and item ready for green tag. This QA Inspector issued green tags for Longitudinal Diaphragms on this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB019-009) Green Tag- 009970.

This QA inspector observed the following work in progress:

Bay#3

SAW welding of weld joint CB202C-014-004 located on CB202-014. Welder is identified as 062406 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint CB202F-014-001/002 located on CB202-014. Welder is identified as 062406 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint fit-up verified by SMAW welding process of weld joint CB202B-014-001 located on CB202-014. Welder is identified as 058102 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS

Bay#2

Joint fit-up verified by SMAW welding process of weld joint FB3059-003, 005, 022, 023, 024 located on FB3059-003. Welder is identified as 205098 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS

Bay#8

SAW welding of weld joint CB202C-013-003/004 located on CB202-013. Welder is identified as 207463 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Patel,Hiranch

Quality Assurance Inspector

Reviewed By: Prue,Erik

QA Reviewer